

Date: Thursday, 6/22/2006 9:46:57 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 27643		
Estimate Number	: 10913		
P.O. Number	: N/A	Part Number	: D3405043
This Issue	: 6/22/2006 S.O. No. : N/A	Drawing Number	: D3405 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/19/2006 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 26515	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 7/15/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	10 Um: Each
Comment	: Est A 05.09.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet
	Comment: Qty.: 0.1540 sf(s)/Unit Total : 1.5400 sf(s) 304/316 .125 Sheet <i>M 101463</i> <i>06 07 07</i>	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET <i>06 07 07</i> (10)	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>06 07 07</i> (10)	
4.0	QC8	SECOND CHECK
	Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3405 <i>06 07 10</i> (10)	
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Deburr Form using DT8204 as per Dwg D3405 <i>SAD 06:07:12</i> (10) <i>06/07/20</i> (10)	
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP <i>06 07 20</i> (10)	

Date: Thursday, 6/22/2006 9:46:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27643

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

Bab536

M18712

PD 06-07-27 (10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

PD 06-07-27 (10)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

AA 06/07/27 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-01

(10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PD 6/8/01 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

6/8/2
06/08/02

(10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PD 06/08/03 (10)

Job Completion




C206/08/03

DART AEROSPACE LTD	Work Order:	27643
Description:	Part Number:	3405-013-3
Inspection Dwg: D3405, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

[illegible]

Measured by: 	Audited by:	Prototype Approval:
Date: 26 07 07	Date:	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Date: Monday, 6/19/2006 11:30:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27643

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

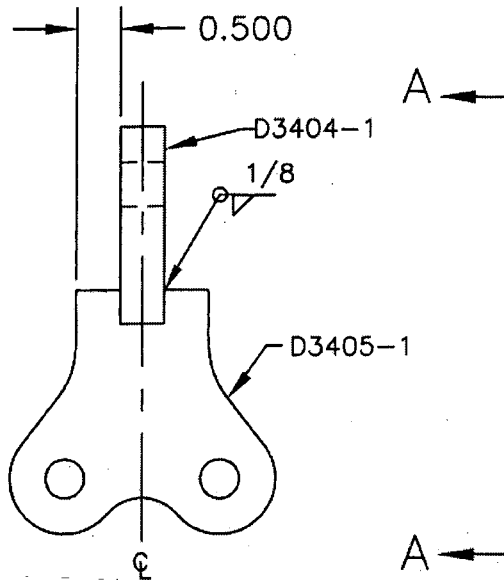
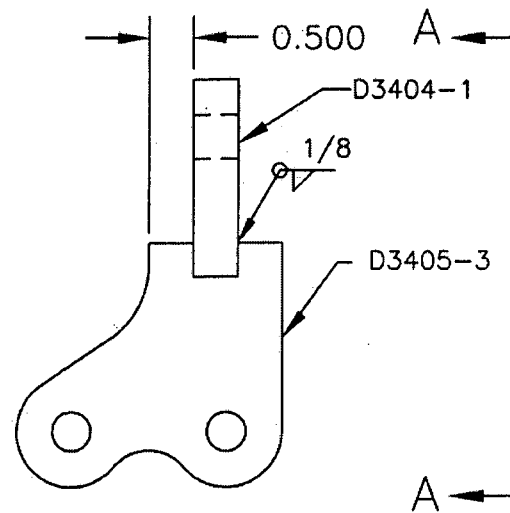
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 2/18/13

NOTE: Date & initial all entries

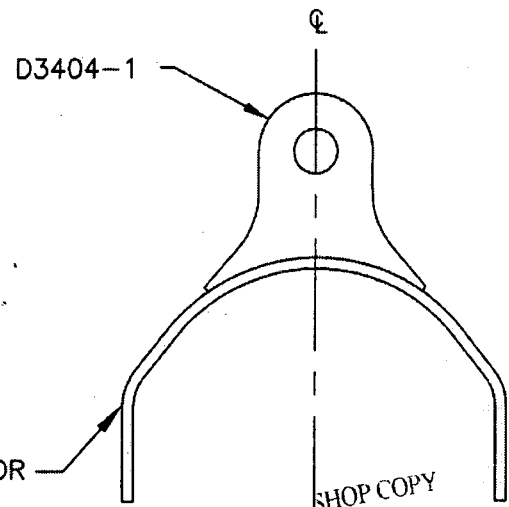
QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09D3405-1 OR
D3405-3

SHOP COPY
RETURN TO
VIEW **ENGINEERING**
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **27643**

D3405-041/-043 LUG ASSEMBLY

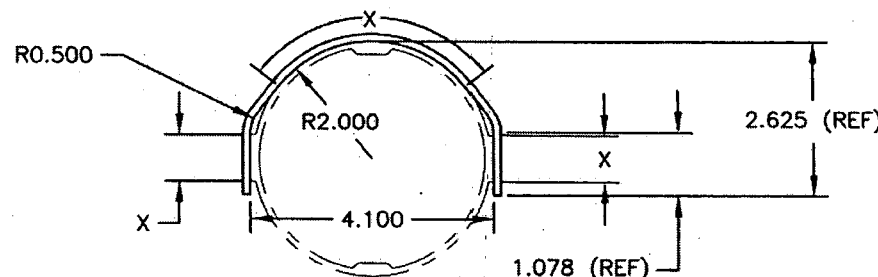
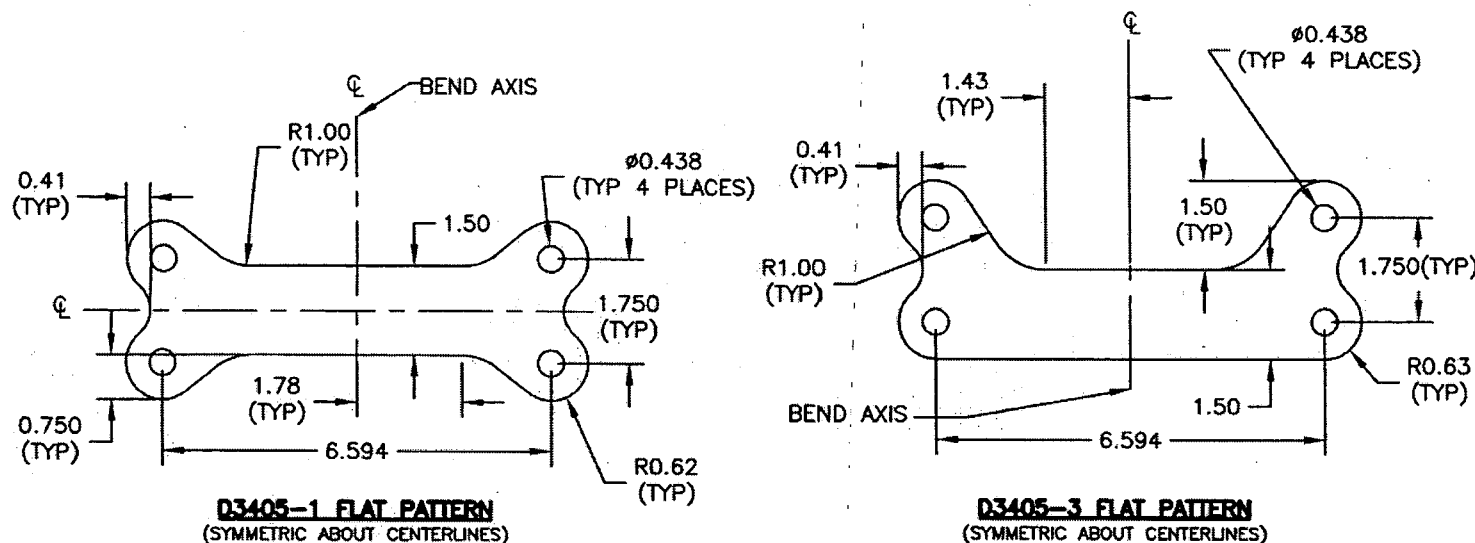
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-08-04
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 27643
WORK ORDER
SHOP COPY
RETURN TO
ENGINEERING

Date: Monday, 6/19/2006 11:30:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 27643		
Estimate Number	: 10913		
P.O. Number	:	Part Number	: D3405043
This Issue	: 6/19/2006 S.O. No. :	Drawing Number	: D3405 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 26515	Material	:
Written By	: <u>JA 06.06.19</u>	Due Date	: 7/15/2006 Qty: 10 Um: Each
Checked & Approved By	: <u>JA 06.06.19</u>		
Comment	: Est A 05.09.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3405

Material release note is required

Identify as D3405-3

(M304S116A)

304 SS .125" THK.

(.154 SF)

Batch: M101463

M 0707

2.0

D34053F

GHW Bracket



Waterjet.

Dwg Rev: A

Prj Rev: A



Comment: Qty.: 1.0000 U(s)/Unit Total: 10.0000 U(s)

G H W BRACKET

M 0707

(10)

3.0

PACKAGING 1

QC2

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

M 0707

(10)

4.0

QC6

QC8

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3405

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27643

Part Number: D3405043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7.0	D34041	GHW Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

9.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____